

Date  
UserThursday, 16/08/2007 10:31:19 AM  
Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 34006  
 Estimate Number : 10464  
 P.C. Number : N/A  
 This Issue : 16/08/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : SMALL /MED FAB  
 Previous Run : 33430  
 Written By :  
 Checked & Approved By :  
 Comment : Est:A 04.04.19 New issue KJ/JLM

Drawing Name : SUPPORT ASSEMBLY

Part Number : D3278041

Drawing Number : D3278 UNDER REVIEW OK PER REV. C

Project Number : N/A

Drawing Revision : B/C

Material : N/A

Due Date : 10/09/2007

Qty: 40 Um: Each

07.08.16 DC  
REF ECALF 1003  
38

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 34006A SUPPORT



Comment: Sub-Component SUPPORT

D3278-1 B 32657 x 38

ml

2.0 34006B SUPPORT



Comment: Sub-Component SUPPORT

D3278-2 B 31838 x 3

B32657B x 35

ml

3.0 D32783 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 38 40.0000 Each(s)

Spacer

Pick:

Qty Part Number

Description

Batch

1 D3278-3

Spacer

B33454 x 33

B34024 x 5

ml 07/08/21

4.0 MS20426AD316 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 152 160.0000 Each(s)

RIVET

Pick:

Qty Part Number

Description

Batch

4 MS20426AD316

Rivet

M1050554 x 65

M16527 x 87

ml 07/08/21

07.08.16 DC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, 16/08/2007 10:31:19 AM

User:

Linda Lacelle

## Process Sheet

Customer: GU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 34006

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



x38

Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

ml 07/08/21

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/23 (x38)

7.0

D22301

Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~80.0000~~ Each(s) 76

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

B32163

ml

8.0

AN413A

Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~80.0000~~ Each(s) 76

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

M104746

ml

9.0

AN960JD416

Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~160.0000~~ Each(s) 152

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

M104215

ml

10.0

MS21042L4

Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~80.0000~~ Each(s) 76

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

Description

Nut

Batch

M103914

07/08/22 ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 34006

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

X38

ml 07/08/22

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/23

caento  
X38

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

0207/08/25

38

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

38  
Herk 07/27

Job Completion



u 07-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

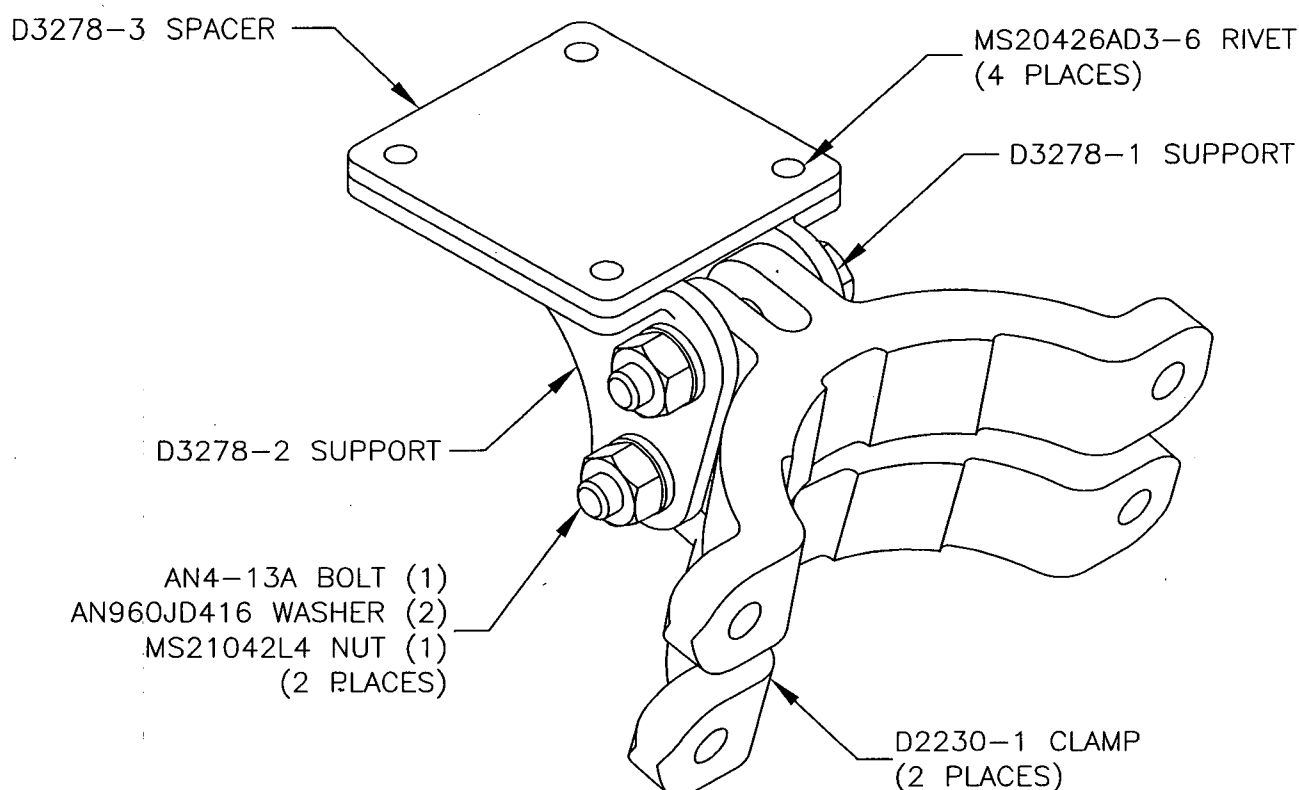
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07.08.08*

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

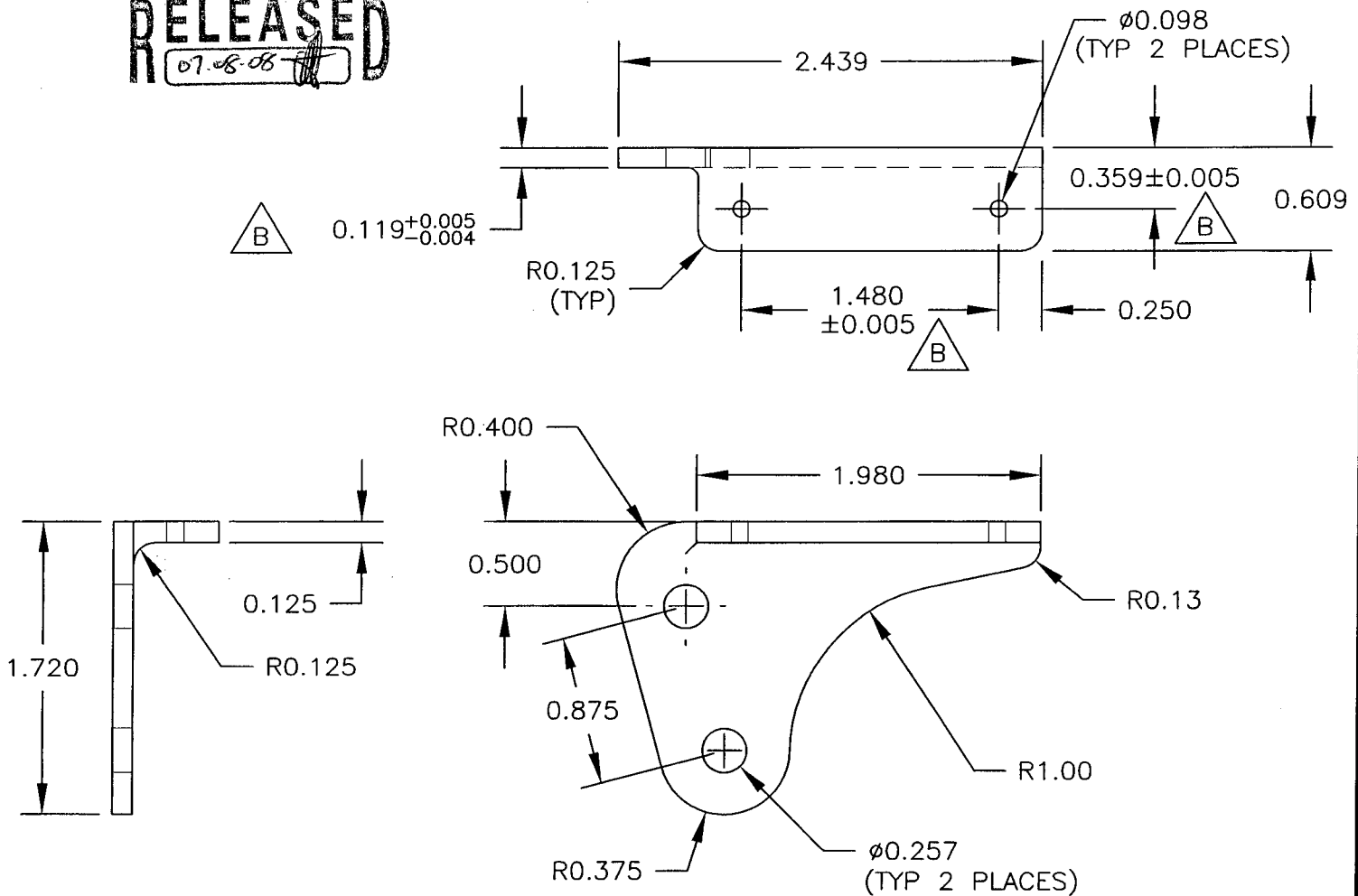
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DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED  
07.08.08



**D3278-1 SUPPORT (SHOWN)**

**D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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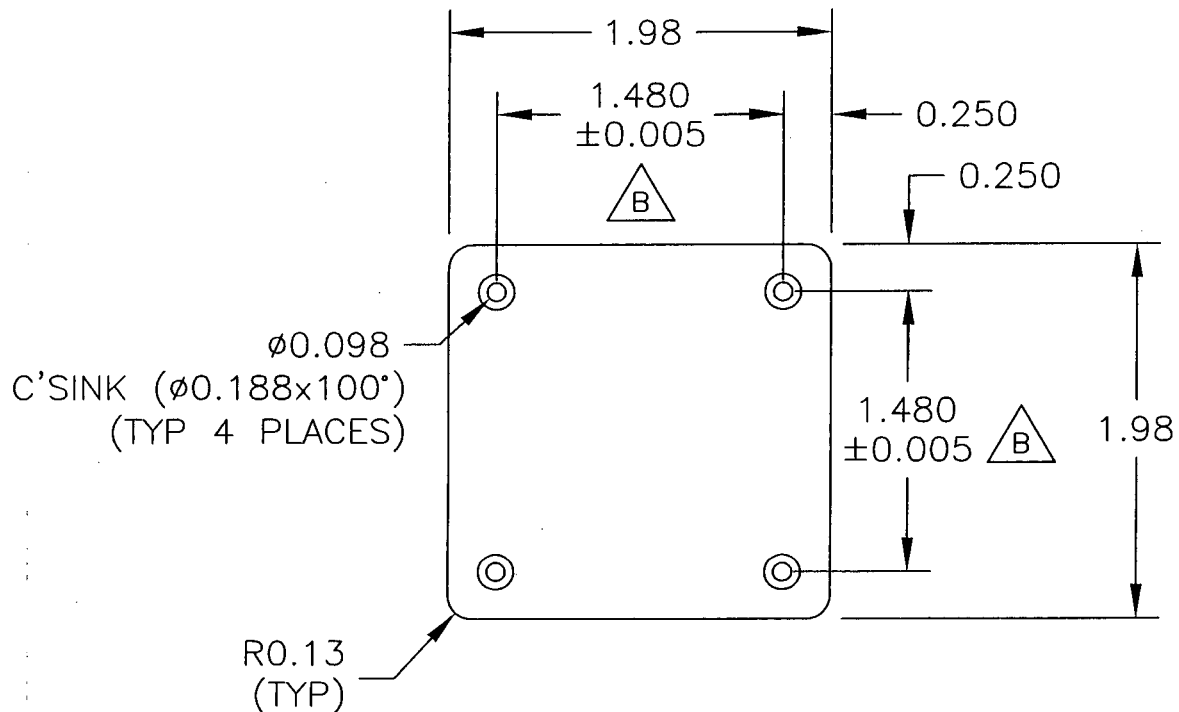
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DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED  
07.08.08



### D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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